Work Orde June-12-13 9:1		02837			*102	2837*							Page 1
Item ID: Revision ID:	D3161-3				Accept	*N900	040	100	*	Setup	Start	*N!	S1*
Item Name:	Hinge 15.0"										Stop	*N:	S2*
Start Date:	6/11/13	Start Qty	: 6.00	*6*		Cust Item	ID:						
Required Date: Reference:	: 6/11/13	Req'd Qt	y: 6.00	*6*		Customer:							
Approvals:	Process Pl	lan: M		Date: 13-6-12	Tooling:	D	ate:	_		Run	Start	*N	R1*
					SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	, D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr	a.										
D3161	Re	ev A2				:							
100 <b>*1</b> Small Fab		Small Fab			0.00			6	ox_				Di,
Small Fab			<b>Memo</b> Cut to length	as per dwg ( 15.0" long )		close.Deburr if			7			//	
	. #		necessary	, , , , , , , , , , , , , , , , , , ,	,								
			*-					••				-	
110		QC5- Inspec	t part comple	eteness to step on W/O	2 1 ~ 00.0	1							
*110*			Memo		0.00 (DAS	Blooley	,		(4(e)	<u> </u>			·
Quality Control			r		•		·	Marie .					
120		Identify as p	er dwg & Sto	ock Location: 5703	0.00	y tan in a		de la la	<b>ţ</b> .				,

0.00

Memo

\*120\* Packaging

Packaging

DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-((	JNFOI	RIVIAINCE / U		Nork Orde	er up	date only	AEROSPAC	E
Mork Orda						DISPOSITION				AGAINST [	DEPARTM	ENT/	PROCESS		
Work Orde	er:				_	Rework	1		Skid-tube	Crosstube			Water Jet	Engineering	
Part N	do.					Scrap			Machining	Small Fab		Proc	d. Eng. Coor.	Quality	
raiti	•••-					Use-as-is			noforming	Finishing	Rec		e/Packaging	Other	
NCR N	No.					Suspected Unapproved		111.011	Large Fab	Composite		0101	Supplier		
							,			٠ ـ ـ	J				
Root	:				Desci	ription of work order update	1	nitial	Ac	tion	Sign	&			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Dat	e	Verification	QC Inspector	
Design						·									
Doc/Data	Ш							•							
Equip/Tooling										-					
Handling/Pre	Ш						İ								
Material															
Operator	Ш								:						
Offset/Setup															
Process															ſ
Supplier															
Training	Ш														
Transport	Ш														
Unapproved			<u> </u>				<u> </u>								
							FA	ULT CA	TEGORY	-					
Landi	Landing Gear					General	_	1		г	<b>-</b> .		r	<b>-</b>	
	Bending				_	Bend	$\vdash$	•	Program	,			ensions	Pressure/Forced	
	Centre Not Concentric			ntric	_	BOM/Route	<u></u>	Grain		-			tolerance	Set-up	
	Cracks				<u> </u>	Broken/Damage/Defect	┕	Hardwa			Part Inc		<b>—</b>	Temperature/Cure	
	Crimp/Kink/Ripple/Wave				<u> </u>	Burrs	$\vdash$	1	ion Incomplete/L		Part Lo		ssing	Weld	
	Cuffs				_	Contamination	<u> </u>	4	tions Incomplete/	'Unclear	Part Mo		L	Wrong Stock Pulle	t
	Crushing			<u> </u>	Countersink	$\vdash$	-1	gned/off center	}	Position			<del></del>		
	Heat Treat			<u> </u>	Cut Too Short	<u></u>	Mislab		L	Power	Loss/S	Surge	Other		
	$\vdash$		n Strip in	Tube		Drawing	<u></u>	Misrea							
	$\vdash$	/larks/Ch			<u> </u>	Drill Holes	<u></u>	Off-set							
	Turning Sequence				<u> </u>	Finish		-1	Calibration						
	Wave/Twist in Tube					Fit/Function	1	I Out of	Saguanca						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord June-12-13 9: I		2837		*102					Page	2			
Item ID: Revision ID: Item Name:	D3161-3 Hinge 15.0"	4 4 4		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	1 71	S1* S2*	
Start Date: Required Date Reference:	6/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:							
Approvals:	Process Pl		Date:	Tooling: SPC (Y/N):	· · · · · · · · · · · · · · · · · · ·	nte:			Run	Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center 1 130 *130* QC Quality Control	ID .	Operation Description QC21- Final Inspection Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	13/-	Reject Number 7/8	Insp. Stamp	_
()											MF (3:	7-5	

DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Wor	k Order up	date only	AEROSPAC	Ē
				٠		DISPOSITION				AGAINST I	DEP	ARTMENT	PROCESS	•	
Work Orde	er: _					_	.			_	_	•	_		
						Rework	1		Skid-tube	Crosstube	_		Water Jet	Engineering	
Part N	اo		<del></del>			Scrap			Machining	Small Fab	_		d. Eng. Coor.	Quality	
						Use-as-is		Thern	noforming	Finishing	_	Rec/Stor	e/Packaging	Other	
NCR N	No					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update	ı	nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief <sub>,</sub> Eng	Desc	ription		Date	Verification	QC Inspector	
Design														·	
Doc/Data														:	
Equip/Tooling	Ш													:	
Handling/Pre	Ш														
Material	Ш														
Operator	Ш														
Offset/Setup	Ш														
Process	Ш						1								ļ
Supplier	Ш						İ								
Training															
Transport	Ш														
Unapproved							<u> </u>								
							FAL	ULT CA	TEGORY					-	
Landi	ng G	ear				General		1		-			_		
	Bending				<u> </u>	Bend		1	Program		-	Outside Dim	<b>}</b> −	Pressure/Forced	
	Centre Not Concentric					BOM/Route		Grain			Щ	Over/Under	tolerance	Set-up	
	Cracks					Broken/Damage/Defect		Hardwa	ire			Part Incorred	ct	Temperature/Cure	
	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ion Incomplete/U	nqualified	LJ <sup>f</sup>	Part Lost/Mi	ssing	Weld	
	Cuffs					Contamination		1	tions Incomplete/	Unclear		Part Moved	L	Wrong Stock Pulled	j
	Crushing					Countersink	<u></u>	•	ned/off center		-	Positioned <b>V</b>		_	
	Heat Treat				Cut Too Short	<u></u>	Mislabe	eled	Į		Power Loss/	Surge	Other		
	$\vdash$	Inspectio	· · · · · · · · · · · · · · · · · · ·	Tube		Drawing	L	Misrea	d		_				
	Ш	Marks/Cl	natter			Drill Holes		Off-set							
	Ш	Turning S	equence			Finish		Out of	Calibration		_				
	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence							

June-12-13 9:15:06 AM

Page 1

Work Order ID:

102837

Parent Item:

D3161-3

Parent Item Name:

Hinge 15.0"

**Start Date:** 6/11/13

Required Date: 6/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A02.04.26New IssueNG

111 A02.04.2010W 1330C110

IPP Rev:B	08-04-29	update seq. 1	DD	verified by:ec

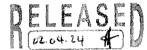
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200 Piano Hinge		Purchased	No			100	f	70.3753	1.44	9.0947368 C		23/	07/0
-				<b>Location</b>		Loc Oty	Lo	c Code				/	
•				ST209a		70.3752628							
				12396	60	6.4552628				<del></del>			
				12544	45	63.92			9,	07473	68		

DQA:		Date:	·		WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:		Date			WORK ORDER NON-	-CC	JINFO	RIVIAINCE / U		/ork Order up	odate only	AEROSPACE		
Work Orde	r.				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS			
Part N					Rework Scrap		i i	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality		
NCR N				<del></del>	Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite		re/Packaging Supplier	Other		
Root				Desci	ription of work order update		nitial	Ac	tion	Sign &				
Cause	Dat	e Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training														
Transport														
Unapproved		i	_1	L		FΔI	UI T CA	TEGORY			<u> </u>			
Landi	ng Gear				General									
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave				Bend BOM/Route Broken/Damage/Defect Burrs		Grain Hardwa	Program are ion Incomplete/U	Inqualified	Outside Dim Over/Under Part Incorred Part Lost/Mi	tolerance	Pressure/Forced Set-up Temperature/Cure Weld		
	Cuffs				Contamination		Instruc	tions Incomplete/	'Unclear	Part Moved		Wrong Stock Pulled		
	Crushing Heat Treat				Countersink Cut Too Short		Misali Mislab	gned/off center eled		Positioned V Power Loss/		Other		
	Inspe	ction Strip i	n Tube		Drawing	Misread			_					
	Mark	/Chatter			Drill Holes	Off-set								
	Turni	ng Sequence	e		Finish		Out of	Calibration						
	Wave	/Twist in Tu	ihe		Fit/Function	Out of Sequence								





DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA							
CHECKED FF	APPROVED	DRAWING NO.	SHEET !	REV. OF						
DATE 02.0	4.24	HINGE		sc.	TS					



	02.04.24	HINGE	NTS
 Α	02.04.24	NEW ISUE	
AL		ADDED DBIGI-5	
<u> 192</u>	D-# 04.06 30	ADD 03161-7 & 03161-	· · · · · · · · · · · · · · · · · · ·

P/N	LENGTH 'L
D3161-1	13.5"
03161-3	15.0
DOTET-5	9.9"
03161-7	14,0"
03161-4	17.0

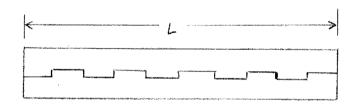
## DESCRIPTION

HINGE (REPLACES MS 20257-3-13.5 ON D2183) HINGE (REPLACES MS 20257-3-150 ON D2950-041)

HINGE

HINGE

HINGE



## NOTES:

1) MAKE FROM MS20257-3-7200 HINGE



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DQA:		Date:				_						T A A RT
QA Closed:		Date:	:		WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE	W	ork Order up	date only	AEROSPACE
Work Orde					DISPOSITION			AGAINS		PARTMENT		
WOIK OIGE	:ı. <u> </u>			<del></del>	Davisant	1			_	1	\44a4aa	¬
Part N	lo				Rework Scrap Use-as-is			Skid-tube Crosstub Machining Small Fal	b	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Suspected Unapproved		men	noforming Finishin Large Fab Composit	-	Rec/Stoi	re/Packaging Supplier	Other
Root				Desc	ription of work order update		Initial	Action		Sign &		
Cause	Dat	e Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup。												
Process												
Supplier							_					
Training										·		
Transport												
Unapproved												
						FA	ULT CA	regory	•	****		
Landi	ng Gear				General			•				
	Bend	ng		1-1	Bend	Г	Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centr	e Not Conce	entric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Crack	Cracks			Broken/Damage/Defect		Hardwa	are	-	Part Incorred	ct	Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination	Г	Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing			Countersink		Misalig	gned/off center		Positioned V		<del></del>	
	Heat Treat				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspe	ction Strip ir	n Tube		Drawing	Misread				-	_	
	Mark	s/Chatter			Drill Holes		Off-set					
	Turni	ng Sequence	9		Finish		Out of	Calibration				
·	Wave	/Twist in Tu	be		Fit/Function	Out of Sequence						